Work Order ID 52639

October 5, 2009 11:32:02 AM

Item ID: PB67-43001-147 **Accept** **Setup Start** **Stop**

Revision ID: C

Item Name: Support Plate

Start Date: 10/05/2009 **Start Qty:** 27.00 **Cust Item ID:**

Required Date: 10/08/2009 **Req'd Qty:** 27.00 **Customer:**

Reference:

Approvals: **Process Plan:** MNF **Date:** 09-10-05 **Tooling:** **Date:** **Run Start** **Stop**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
B67-43001	C								
100		0.00							
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg PB67-43001-147 Dwg Rev:_____ Prog Rev:_____ 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00							
Quality Control									

See Attached w/o

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 52639

October 5, 2009 11:32:02 AM

Item ID: PB67-43001-147 **Accept** **Setup Start**

Revision ID: C **Stop**

Item Name: Support Plate

Start Date: 10/05/2009 **Start Qty:** 27.00 **Cust Item ID:**

Required Date: 10/08/2009 **Req'd Qty:** 27.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									
130	Bend as per dwg	0.00							
Brake NC	**Memo**	0.00							
Brake NC									
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

See ATTACHED W/O

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 52639

October 5, 2009 11:32:02 AM

Item ID: PB67-43001-147 **Accept** **Setup Start** **Stop**

Revision ID: C

Item Name: Support Plate

Start Date: 10/05/2009 **Start Qty:** 27.00 **Cust Item ID:**

Required Date: 10/08/2009 **Req'd Qty:** 27.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: ST.	0.00							
Packaging	**Memo**	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

27

See w/o #52434 Pulled ~~or~~ 27 parts on new w/o (couldn't change part number in old w/o.

09/10/05 MF

MF 09-10-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

October 5, 2009 11:32:02 AM

Work Order ID: 52639

Parent Item: PB67-43001-147RevB1

Parent Item Name: Support Plate

Comments:

Start Date: 10/05/2009 **Required Date:** 10/08/2009

Start Qty: 27.00 **Required Qty:** 27.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.090		Purchased	No			100	sf	114.8403	16.9731			

6061-T6 .090 Sheet

See ATTACHED W/O

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	114.8403	
108595	1.41	
109184	16.3403	
111382	96	
19295	1.09	

already pulled

PB6743001-67.

27 x B-52434 MK 09-10-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 52434

September 23, 2009 2:44:55 PM

Item ID: PB67-43001-~~B7~~ 147 **Accept** **Setup Start**

Revision ID: ~~B1~~ C 09.06.24 **Stop**

Item Name: PB67-43001-~~B7~~ 147

Start Date: 09/24/2009 **Start Qty:** ~~4.00~~ 27 **Cust Item ID:**

Required Date: 10/02/2009 **Req'd Qty:** ~~4.00~~ **Customer:**

Reference:

Approvals: **Process Plan:** MF **Date:** 09-09-23 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr B67-43001-147	**Revision Nbr** ~~Rev B1~~ C 09.06.24								
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg B67-43001-147 ☐Dwg Rev: C ☐Prog Rev: C ☐2-Deburr if necessary					IB 9-9-09			
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				IB 9-9-09			
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00				7			05-05-29
Quality Control									

6061 .090

REV. C 09.09.24 PTC.

PTC

7

REFERENCE ONLY

#100: B67-43001-147 SHOULD BE ON ~~WORK ORDER #~~ ITS OWN WORK ORDER. CREATE B67-43001-147 AND UPDATE WORK ORDER B67-43001-67 ACCORDINGLY. 09.09.24

REFERENCE ONLY

Dart Aerospace Ltd

W/O: 52434	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
05.05.29	W/O	B67-43001-147 should be it's own w/o. Create B67-43001-147 & update accordingly including an FAI sheet. * See back of previous page by Marc. B* Perm change	MF	09-10-08	27	05-05-29	05-05-29

Part No: B67-43001-147 **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

REFERENCE ONLY

Work Order ID 52434

September 23, 2009 2:44:55 PM

Item ID: PB67-43001-67 **Accept** **Setup Start**

Revision ID: B1 C 2011.09.24 **Stop**

Item Name: PB67-43001-67

Start Date: 09/24/2009 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 10/02/2009 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00				27	0		
Small Fab	**Memo**	0.00							
Small Fab	Form as per dwg B67-43001								
140	QC5- Inspect part completeness to step on W/O	0.00				(27)	0		
QC	**Memo**	0.00							
Quality Control									
150	Large Fab	0.00							
Large Fab	**Memo**	0.00							
Large Fab	Weld assembly as per dwg B67-43001								

N/A

REFERENCE ONLY

Work Order ID 52434

September 23, 2009 2:44:55 PM

Item ID: PB67-43001-~~67~~ 147 **Accept** **Setup Start**

Revision ID: ~~B1~~ C H 04.09.24 **Stop**

Item Name: PB67-43001-~~67~~ 147

Start Date: 09/24/2009 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 10/02/2009 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	**Memo**	0.00							
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
180	Small Fab	0.00							
Small Fab	**Memo**	0.00							
Small Fab	Assemble as per dwg B67-43001								

N/A 2

REFERENCE ONLY

Work Order ID 52434

September 23, 2009 2:44:55 PM

Item ID: PB67-43001-~~67~~ 147 **Accept** **Setup Start**

Revision ID: ~~B1~~ C 09.05.24 **Stop**

Item Name: PB67-43001-~~67~~ 147

Start Date: 09/24/2009 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 10/02/2009 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							N/A
	Memo	0.00							
200 Packaging Packaging	Identify as per dwg & Stock Location: ~~N/A~~ ST432	0.00				27	0		
	Memo	0.00							
210 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							

09.10-05

09/10/05

Close at 27

REFERENCE ONLY

cr. New w/o for PB67-43001-147 and pull 27 x 67 on new w/o # 5326

Picklist Print

September 23, 2009 2:44:54 PM

Work Order ID: 52434

Parent Item: PB67-43001-67RevC

Parent Item Name: PB67-43001-67 14+

Comments:

Start Date: 09/24/2009 **Required Date:** 10/02/2009

Start Qty: 4.00 **Required Qty:** 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.090		Purchased	No			150	sf	119.2200	2.5027	4.3797	9-9-09	
6061-T6 .090 Sheet												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	119.22	
108595	1.41	
109184	20.72	109184
111382	96	
19295	1.09	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD3-4		Purchased	No			100	Each	8,221.000	48.0000			
RIVET												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	8221	
104374	4221	
110398	4000	

N/A

PTO

PB67-43001-147 B# x.

REFERENCE ONLY

Picklist Print

September 23, 2009 2:44:54 PM

Work Order ID: 52434

Parent Item: PB67-43001-67RevB1

Parent Item Name: PB67-43001-67

Comments:

Start Date: 09/24/2009 **Required Date:** 10/02/2009

Start Qty: 4.00 **Required Qty:** 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21075L3		Purchased	No			180	Each	275.0000	24.0000			
Nutplate												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	275	
109068	12	
109371	39	
110704	37	
111477	2	
112640	20	
112690	165	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-149RevB1		Manufactured	No			180	Each	25.0000	8.0000			
Side Plate												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	25	
40025	1	
41560	24	

N/A

REFERENCE ONLY

DART AEROSPACE LTD	Work Order:	52434
Description: Support Plate	Part Number:	B67-43001-147
Inspection Dwg: B67-43001 ~~B~~-147 Rev: ~~B1~~ C 8/04/24		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.250	+0.005/-0.001	.254	✓			
~~0.47~~ 0.50	+/-0.030	.471	✓			
0.750	+/-0.010	.754	✓			
2.000	+/-0.030	2.004	✓			
0.090	+/-0.010	.087	✓			
4.00	+/- .030	4.004	✓			
21.15	+/- .030	21.20	✓			

CHANGES BY 8/04/24

Measured by:	HB	Audited by:		Prototype Approval:	N/A
Date:	9-9-24	Date:	08-08-25	Date:	N/A

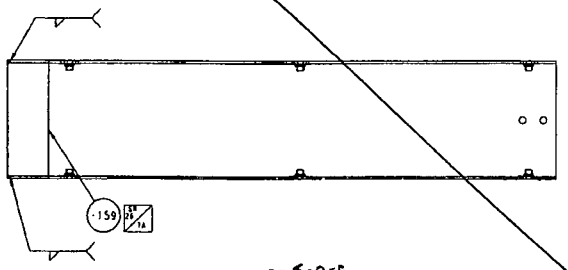
Rev	Date	Change	Revised by	Approved
A	08.07.25	New Issue	KJ/DD	

REFERENCE ONLY

RELEASED

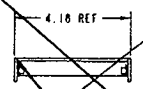
#52434

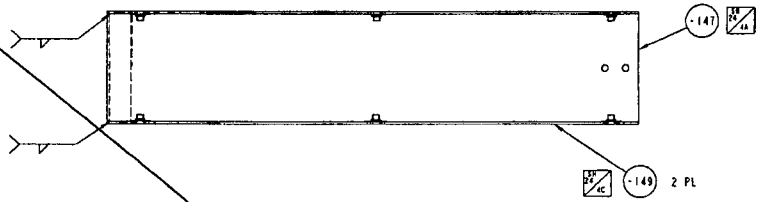
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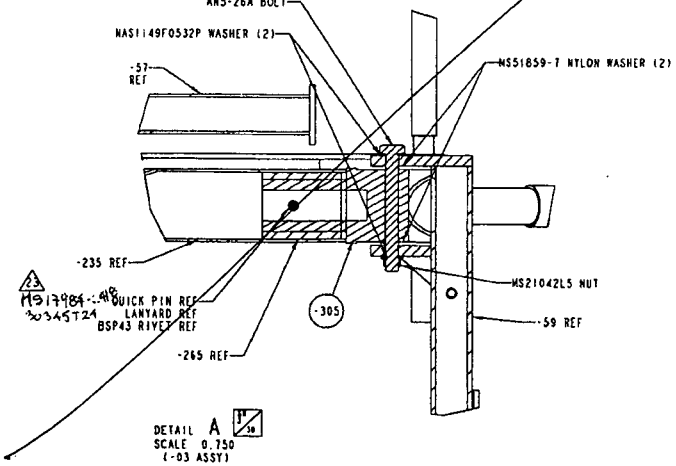


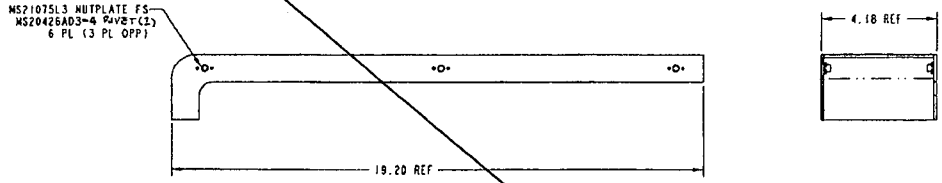
② -71 20 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500









② -67 90 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500

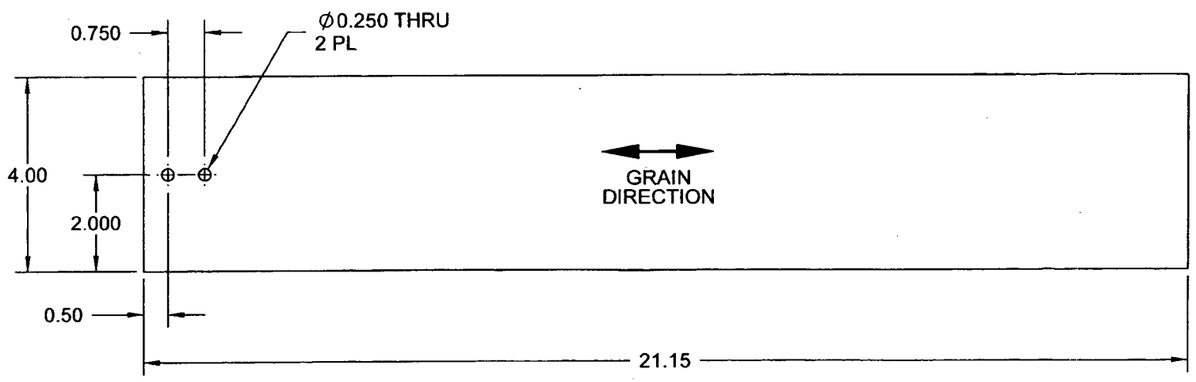
REFERENCE ONLY

PREMIER AVIATION, INC.
2021 Aviation Parkway, Grand Prairie, Texas 75052

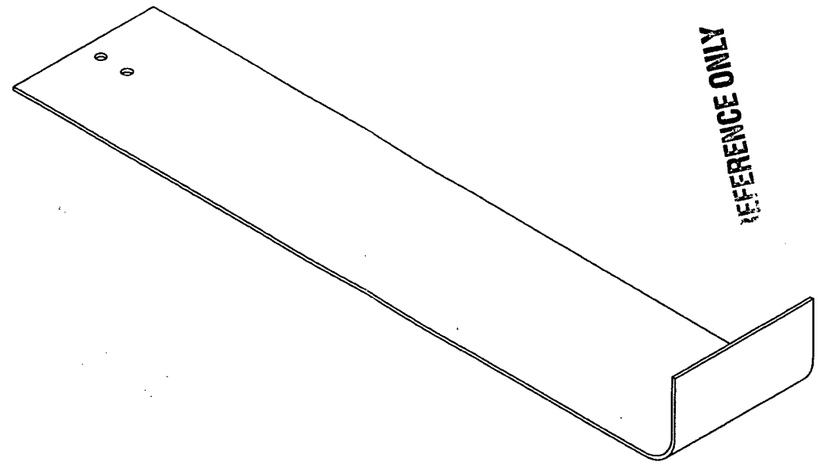
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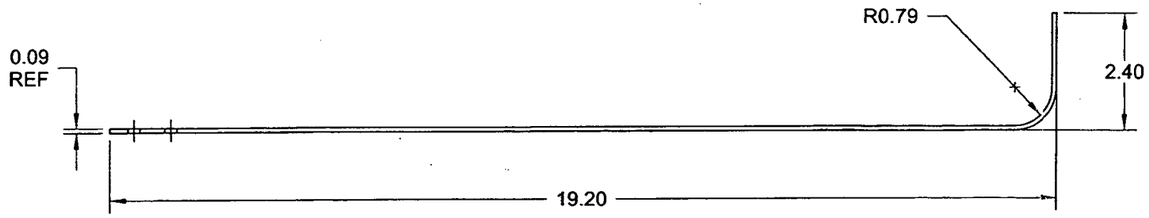
SCALE: WT: SHEET 9 OF 45

ORIGINAL



B67-43001-147F SUPPORT PLATE FLAT PATTERN





B67-43001-147 SUPPORT PLATE
(MAKE FROM B67-43001-147F)

#52434
RELEASED
2009 -09- 24

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.090 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF. DART SPEC. M6061T6S.090
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.74 lbs

REV.	DESCRIPTION	BY	DATE
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISONS, REFER TO PAGE 24 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.03.03

DESIGN	R/W	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. B67-43001-147	REV. C
MFG. APPR.			SHEET 1 OF 1
APPROVED		TITLE SUPPORT PLATE	SCALE NTS
DE APPR.	N/A		
DATE	09.03.03		

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